

For Nov. 1st

Dart Aerospace Ltd.

Date: Monday, 10/16/2006 10:33:34 AM
User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HELI-UTILITY BASKET LH
Job Number :	28985		
Estimate Number :	12554		
P.O. Number :	N/A	Part Number :	D205541043
This Issue :	10/16/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	IIN D205-541 REV F
First Issue :	N/A	Project Number :	N/A
Previous Run :	N/A	Drawing Revision :	F
	Type :	Material :	N/A
	LARGE FAB ASSY	Due Date :	10/30/2006
Written By :		Qty:	1 Um: Each
Checked & Approved By :	[Signature] 06 10 16		
Comment :	Est Rev.C Re-Format 02-08-30 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD205-541-043 CHG002

KS 06.10.16 (1)

2.0	28985A	350/212/130 BASKET LID
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Comment: Sub-Component 350/212/130 BASKET LID
D2512 B 28985A

3.0	28985B	212 BASKET BASE ASS'Y LH
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Comment: Sub-Component 212 BASKET BASE ASS'Y LH
D3053-041

4.0	D2022101	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Spacer
Batch: B 25815

MF 06/11/02

5.0	D2258300	Placard
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Placard
Batch: B 28072

MF 06/11/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 10:33:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET LH

Job Number: 28985

Part Number: D205541043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: B 28246

MF. 06/11/02

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch: B 28247

MF. 06/11/02

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: B 25087

MF. 06/11/02

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: B 28327

MF. 06/11/02

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: B 21139

MF. 06/11/02

11.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M101884

MF. 06/11/02

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100327

MF. 06/11/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET LH

Job Number: 28985

Part Number: D205541043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: m17280

MF. 06/11/02

14.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: m17204

MF. 06/11/02

15.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: m101537.

MF. 06/11/02

16.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: m102339

MF. 06/11/02

17.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: m101237

MF. 06/11/02

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: m102328

MF. 06/11/02

19.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: m11989

MF. 06/11/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET LH

Job Number: 28985

Part Number: D205541043

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M100151

MF. 06/11/02

21.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M101917

MF. 06/11/02

22.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M19099

MF. 06/11/02

23.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M101648

MF. 06/11/02

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: M101519

MF. 06/11/02

25.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg.

MF. 06/11/02

①

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SIB 06/11/02

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET LH

Job Number: 28985

Part Number: D205541043

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

Pickup 1

28.0

D21991

Struts, 19"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Struts, 19"

✓ Batch: *B28071-*

29.0

D219923

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

✓ Batch: *B12793-*

30.0

D219925

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

✓ Batch: *B12794 B11407-*

31.0

D2498

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Bracket

✓ Batch: *B27683-*

32.0

D2499

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Bracket

✓ Batch: *17619-*

33.0

D2515

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

✓ Batch: *B18029*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 10:33:35 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET LH

Job Number: 28985

Part Number: D205541043

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D30521

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Lug

✓ Batch: 1828522 -

35.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Bolt

Batch: M100327

36.0

AN412A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓ Bolt

Batch: M102029 -

37.0

AN413A

Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

✓ Bolt

Batch: M102380 -

38.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Bolt

Batch: M100188 -

39.0

AN57A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Bolt

Batch: M102440 -

40.0

AN513A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Bolt

Batch: M15928 -

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/06

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 10:33:35 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET LH

Job Number: 28985

Part Number: D205541043

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN960JD416

Washer



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

✓ Washer

M102339

42.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓ Washer

Batch: M102328-

43.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

✓ Nut

Batch: M19099-

44.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Nut

Batch: M101648-

PC 4/11/02 (1)

45.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

LB 04/11/02 (1)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-541-043

Location: _____

PPP Rev: E

LB 06/11/03 (1)

47.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

LB 06/11/06 (1)

Job Completion



h 06/11/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

2. GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D205-541.

3. INSTALLATION PROCEDURE

1. If required, install D2498 (STA 84.29), D2499 (STA 155.06), and D3052-1 (STA 129.00) per Figure 5.
2. Locate the D205-541-043/-044 **Utility-Basket™** as shown in Figure 1.
3. Attach the Basket to the A/C hardpoints at STA 84.29, STA 129.00, STA 155.06 as shown in Figures 2, 3, and 4 respectively.
4. Torque AN4 bolts 50-70 in-lbs (5.6-7.9 N-m). Torque AN5 bolts 100-140 in-lbs (11.3-15.8 N-m).
5. If the D3052-1 mounting lug & D2199-1 strut are not installed (at STA 129), the D2258-300 placard on the lid of the basket can be replaced with the D2258-220 placard. The D2258-220 placard can be purchased from Dart.

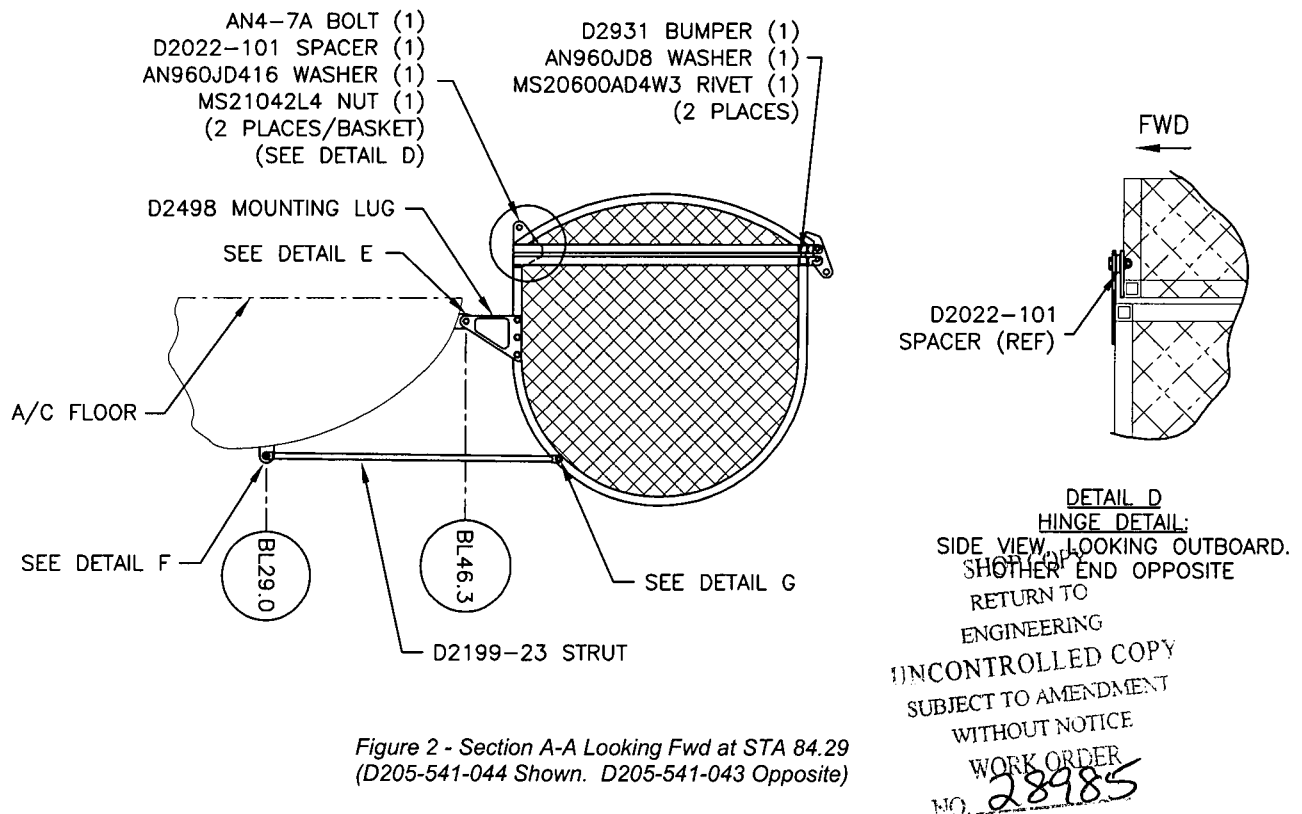


Figure 2 - Section A-A Looking Fwd at STA 84.29
(D205-541-044 Shown. D205-541-043 Opposite)

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Revision: **F**

Date: 06.04.19

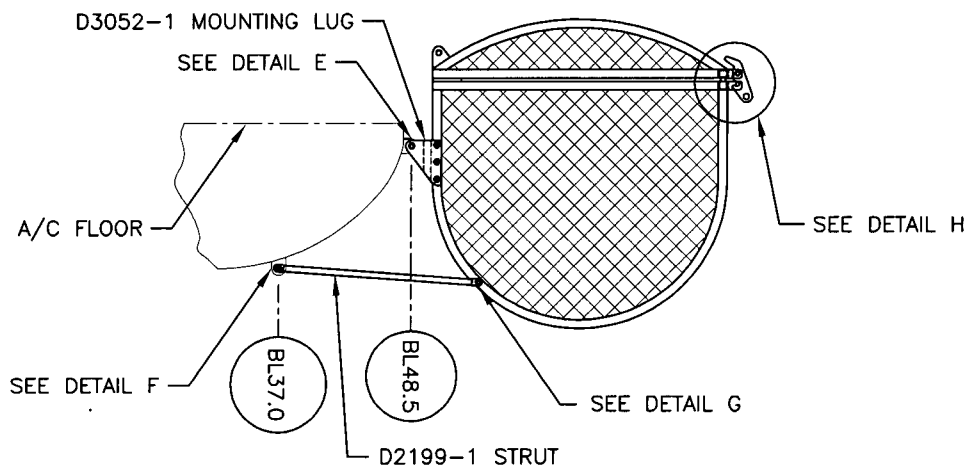


Figure 3 - Section B-B Looking Fwd at STA 129.00
(D205-541-044 Shown. D205-541-043 Opposite)

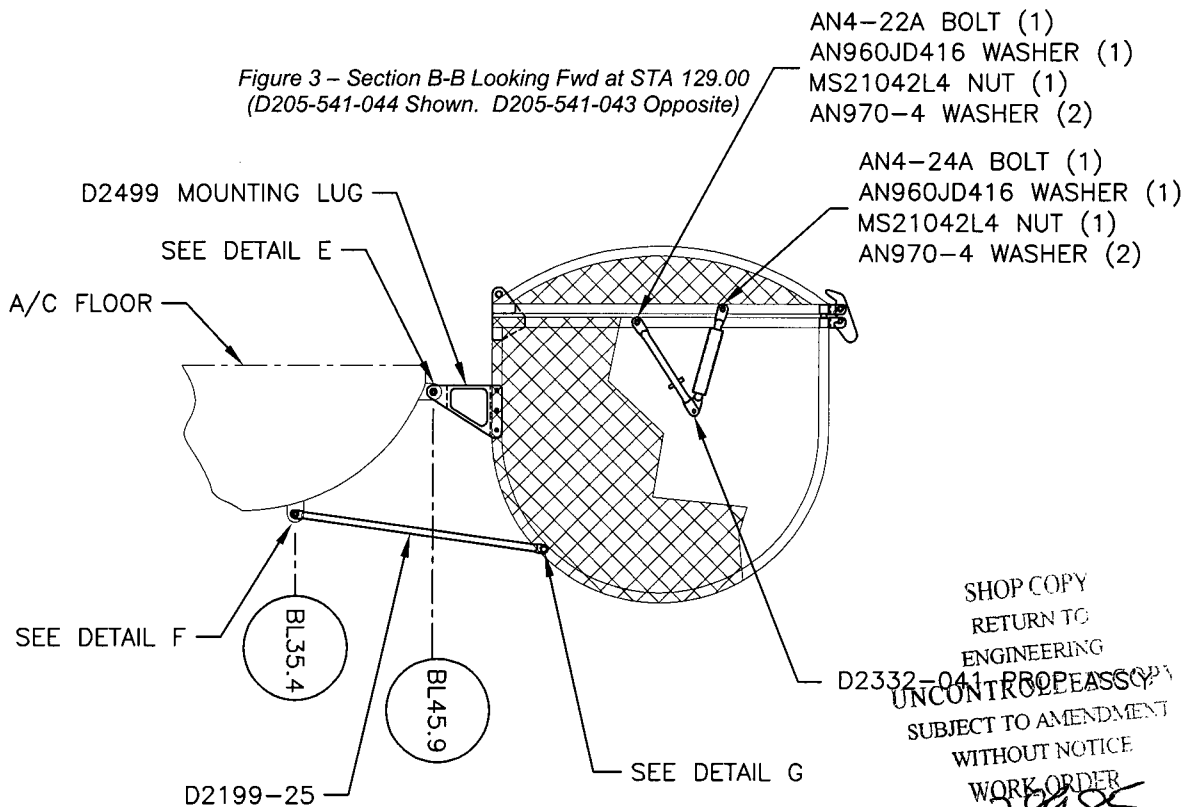


Figure 4 - Section C-C Looking Fwd at STA 155.06
(D205-541-044 Shown. D205-541-043 Opposite)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28985

Date: Monday, 10/23/2006 10:11:11 AM
 User: Eric Charbonneau

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212 BASKET BASE ASSY LH
Job Number	: 28985B		
Estimate Number	: 11542		
P.O. Number	: N/A	Part Number	: D3053041
This Issue	: 10/23/2006 S.O. No. : N/A	Drawing Number	: D3053 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 10/16/2006 Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: _____	Due Date	: 10/30/2006 Qty: 1 Um: Each
Checked & Approved By	: _____		
Comment	: Est. C 02.09.04 M304EX0.75-16F was M750-16FXS-S/SK J/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 45.5000 f(s)/Unit Total : 45.5000 f(s)

304 SQ Tube.75x.75x.065W

Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch:

M102175

M06/10/23

2.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Basket Hoop

Cut

Qty. 5 D3166-1

Batch: B28850

M06/10/23

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

LARGE FABRICATION RESOURCE 1

1-Drill holes in D3053-3 as per Dwg D3053

2-Cut D3166-1 as per dwg D2235-3 detail

****Identify as D2235-3****

M06/10/23

4.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

B28073

M06/10/23

Date: Monday, 10/23/2006 10:11:11 AM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y LH

Job Number: 28985B

Part Number: D3053041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Pick:

Qty	Part Number	Description	Batch
2	D2232-3	Hinge plate	B24527

M06/10/23

6.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	B27587

M06/10/23

7.0	M304EX07516F	Expanded Metal Flat Stai
-----	--------------	--------------------------



Comment: Qty.: 50.4000 sf(s)/Unit Total : 50.4000 sf(s)

Expanded Metal Flat Stai

Pick:

Qty	Part Number	Description	Batch
48sq.ft	M304EX0.75-16F	Expanded Metal	M102394

M06/10/23

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

LARGE FABRICATION RESOURCE 1

Remove all markings from material

Drill holes in three D2235-3 ribs as per Dwg D3053 using Jig DT8365

(Frame) M06/10/25

Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

(x panded Metal) PD 06-10-31

****Ensure ribs are positonned for LH****

9.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------

















Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

VISUAL WELDING INSPECTION

(x panded Metal) PD 06/10/31

(Frame) PD 06-10-31

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 212 BASKET BASE ASS'Y LH	
Job Number: 28985B		Part Number: D3053041	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
10.0	QC6	DIMENSIONAL CHECK	
			
Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs DIMENSIONAL CHECK		(Frame) PD 0610-31 (Expanded Metal) 11/06/03	
11.0	DC	DOCUMENT CONTROL	
			
Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs DOCUMENT CONTROL Take Traveller D205-541-043 to KP		MF. 06/11/01	
12.0	POWDER COATING	POWDER COATING	
			
Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3		y 06/10/01 x1	
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
			
Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs INSPECT POWDER COAT/CHEMICAL CONVERSION		MF. 06/11/02 (1)	
14.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs PACKAGING RESOURCE #1 Identify and Stock Location: G.A.		MF. 06/11/02. (1)	
15.0	QC21	FINAL INSPECTION/W/O RELEASE	
			
Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs FINAL INSPECTION/W/O RELEASE		G 06/11/06 (1)	
Job Completion			
		u 06-11-06	

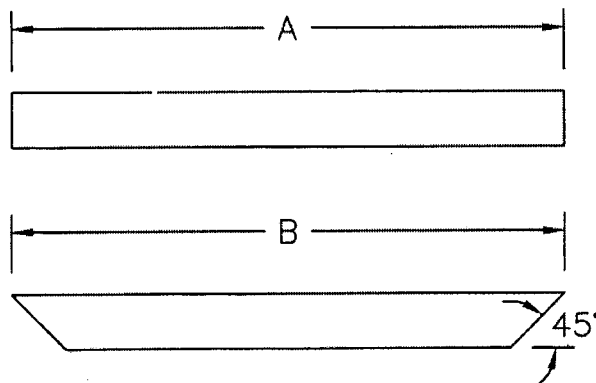


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3053	REV. A SHEET 1 OF 3
DATE 01.11.01		TITLE BASKET BASE ASSEMBLY (212)	SCALE NTS
A	01.11.01	NEW ISSUE	

RELEASED
01.12.20 #

PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	—	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28985B

NOTES:

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

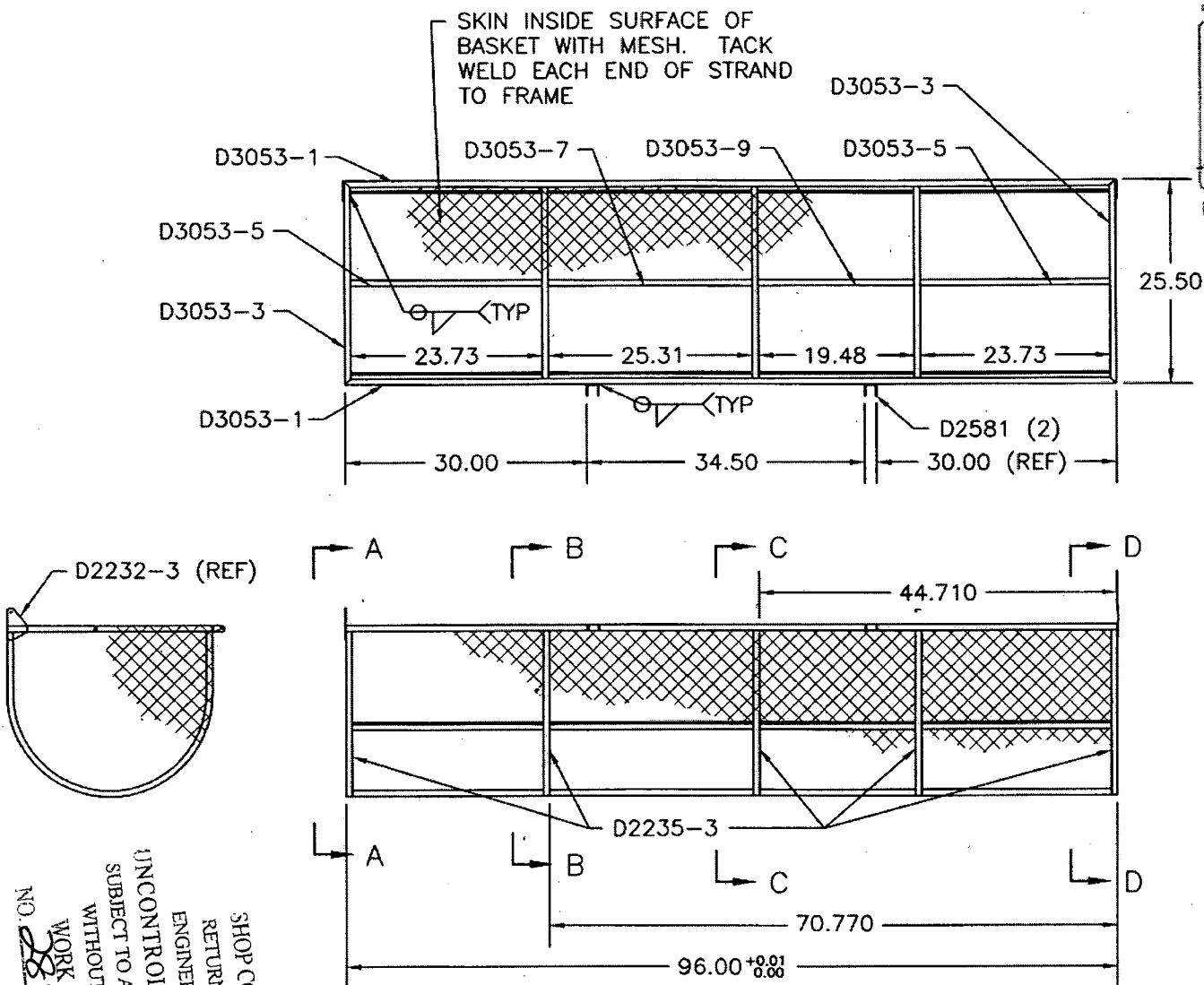
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DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3053
DATE	01.11.01	TITLE	BASKET BASE ASSEMBLY (212)	REV. A SHEET 2 OF 3
		SCALE	1:20	

RELEASED
of 12:20 9/7

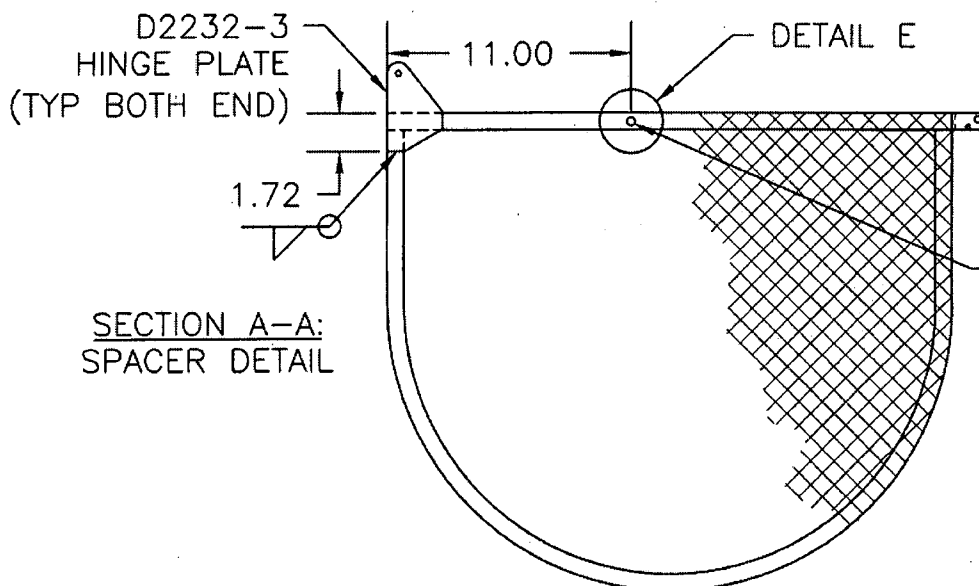


D3053-042 BASKET BASE ASSEMBLY SHOWN
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)

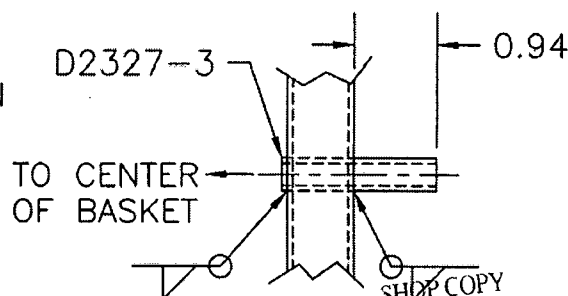
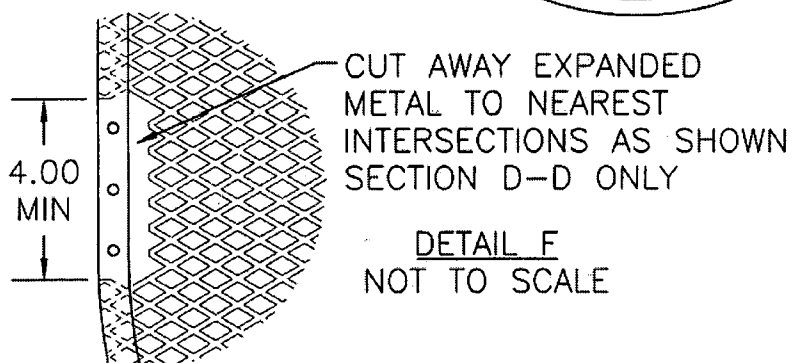
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WORK ORDER
NO. 28985B

DART

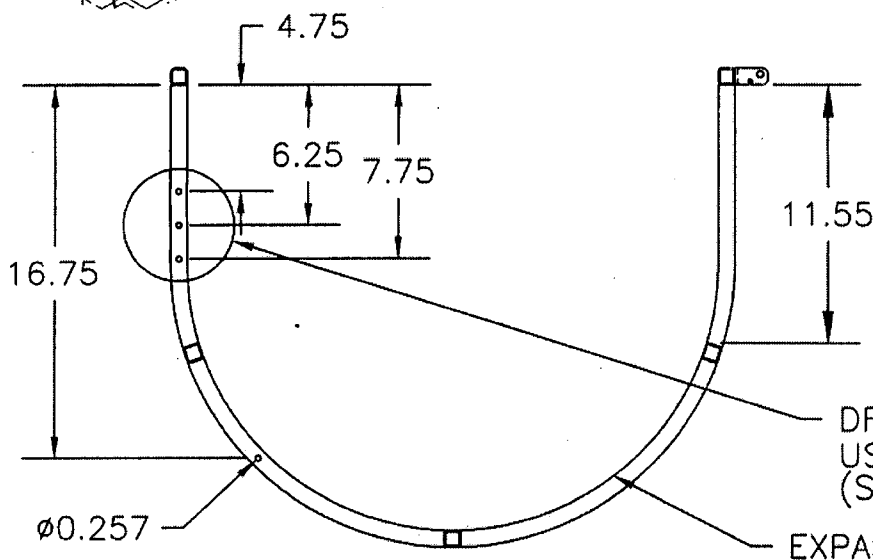
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3053	REV. A SHEET 3 OF 3
DATE 01.11.01		TITLE BASKET BASE ASSEMBLY (212)	SCALE 1:8

**RELEASED**
01.12.20 [Signature]

DRILL 3/8 HOLE
AND INSTALL
D2327-3 USING
CLOSEST SPACE IN
EXPANDED METAL
FOR HOLE LOCATION
BOTH ENDS



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NO. 28785B



SECTION B-B,
SECTION C-C AND
SECTION D-D:
RIB DETAIL

DRILL 0.257 DIA HOLES
USE DRILL JIG T2489DJ
(SEE DETAIL F)

EXPANDED METAL

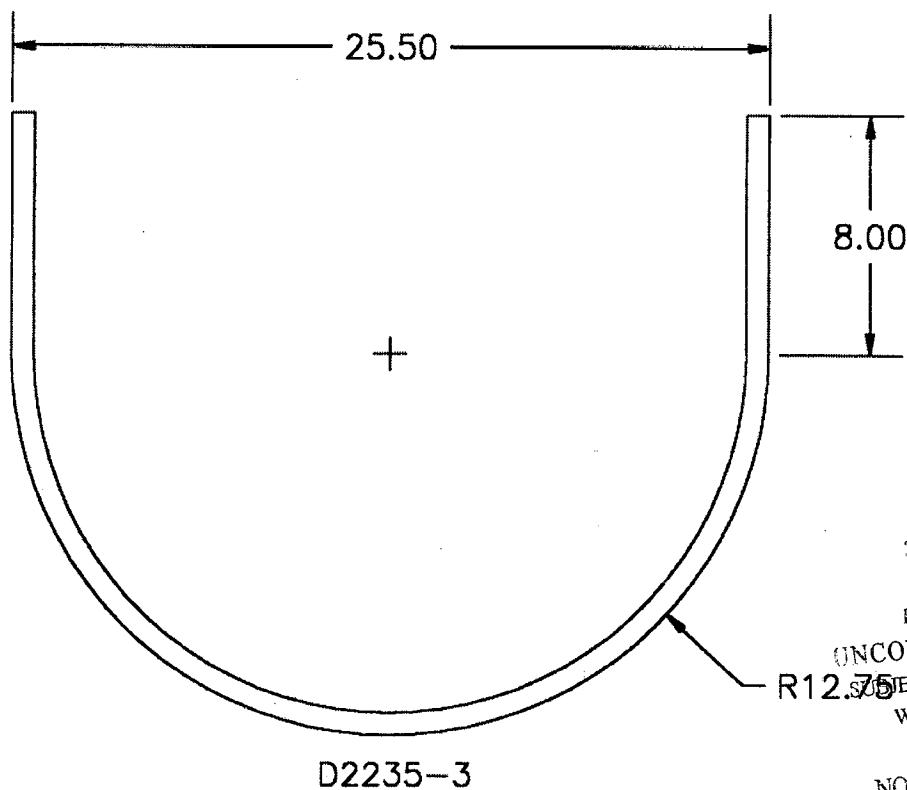
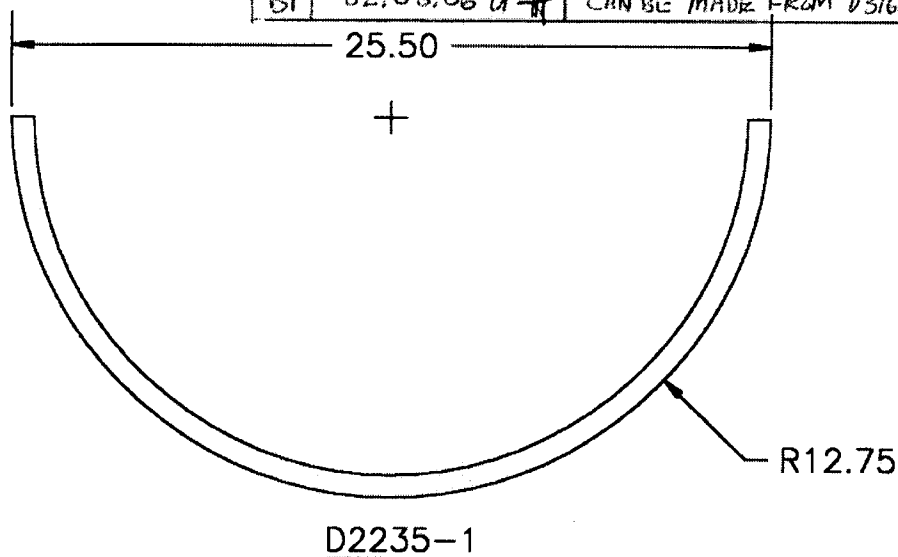
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B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2235	SHEET 1 OF 1
DATE	TITLE		SCALE
94:12:16	BASKET RIBS		
BI	02.08.06 <i>UP-#</i>	CAN BE MADE FROM D3166-1	

RELEASED
R 960507



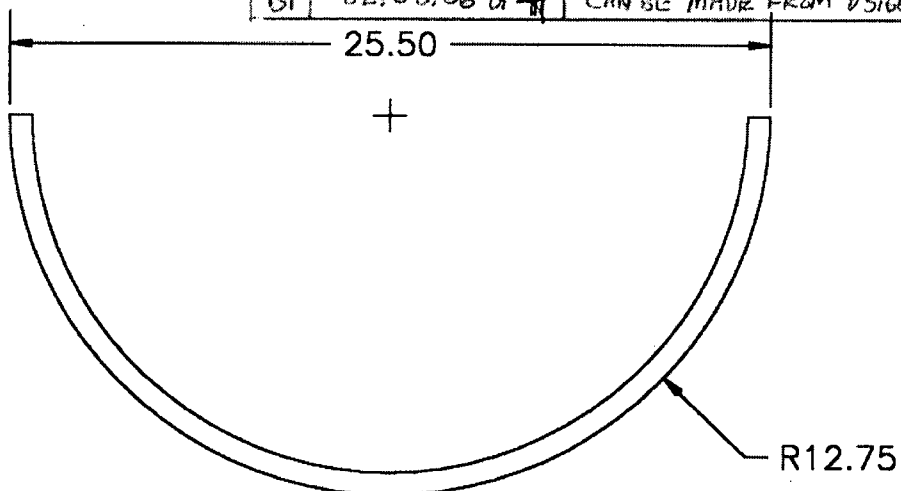
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WORK ORDER
NO. *28985B*

CAN BE MADE FROM D3166-1 *BI*
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

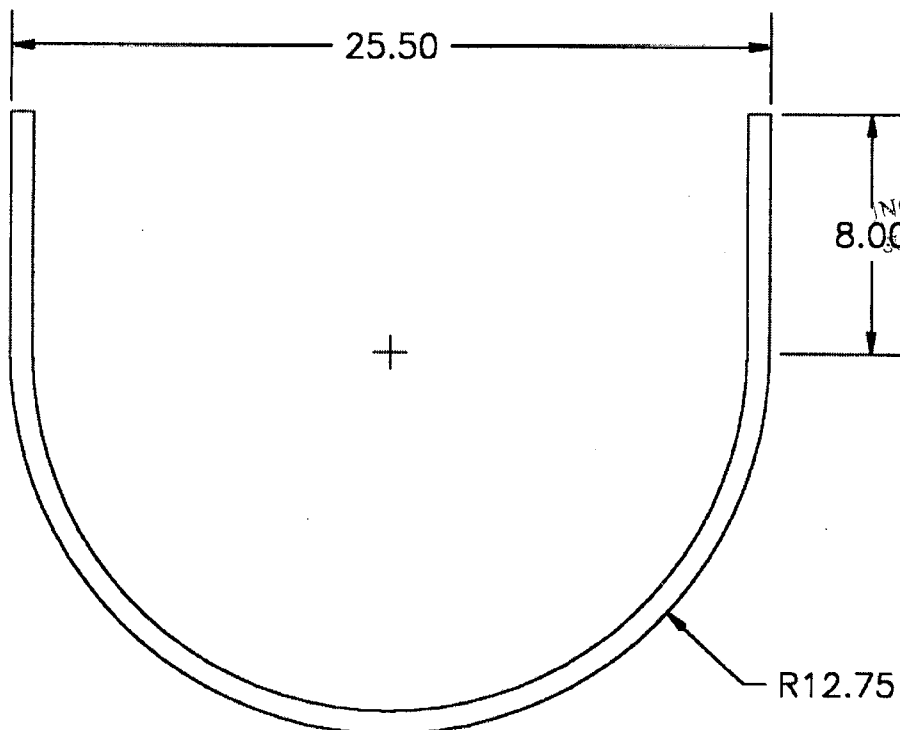


DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2235	SHEET 1 OF 1
DATE	TITLE		SCALE
94:12:16	BASKET RIBS		
BI	02.08.06 <i>U#</i>	CAN BE MADE FROM D3166-1	


RELEASED
960507



D2235-1




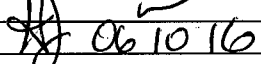
D2235-3

CAN BE MADE FROM D3166-1 
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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WITHOUT NOTICE
WORK ORDER
NO. *29004*

Date: Monday, 10/16/2006 10:33:49 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/212/130 BASKET LID
Job Number	: 28985A		
Estimate Number	: 10193		
P.O. Number	: N/A	Part Number	: D2512
This Issue	: 10/16/2006	Drawing Number	: D2512 REV D2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: D2
Previous Run	: 28842A	Material	: N/A
Written By	: 	Due Date	: 10/30/2006
Checked & Approved By	:  06/10/16	Qty:	1
Comment	Rev Est:M 05.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC		
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W



Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)
 Pick:
 3/4"x3/4" 304/316 SS tube .063" wall
 Batch: M102137

06/10/24

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 1 D3166-3 Basket Hoop 628525

06/10/24

3.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 1 D2506 Label Plate B26631-2

06/10-31 (1)

4.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D2327-1 Bushing 628334

06/10/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 10:33:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 28985A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2232-1 Hinge plate

B 25238

06/10/24

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2581 Mounting Bracket

B 27587

06/10/24

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M102394

PD 06-10-30

①

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

(Frame) 06/10/25

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

(Expanded Metal) PD 06-10-31

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

9.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

(Expanded Metal) 06/10/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 06/11/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 10:33:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 28985A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

yl 06/11/01 x1

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch:

M102098 yl 06/11/01 x1

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf. 06/11/02

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *G.A.*

mf. 06/11/02 ①

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/06 ①

Job Completion



u 06/11/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

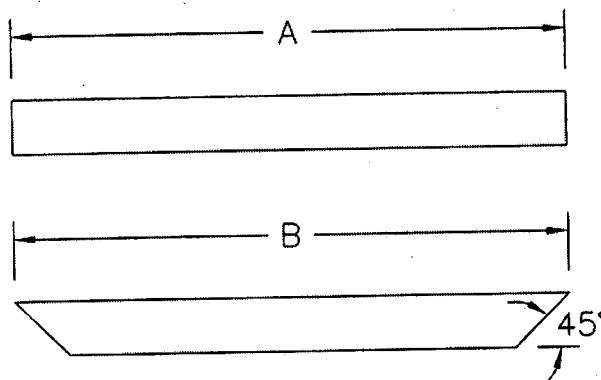


DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE NTS
A	95.11.21	NEW ISSUE	
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE	
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074	
D	01.04.19	CHANGE HINGE	
D1	# UP 03.01.20	ADD D2012-117 FOR D130-701-041	
D2	# UP 04.09.20	TACK WELD ANT-SKID AREA	

RELEASED
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



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NO. 28985A

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

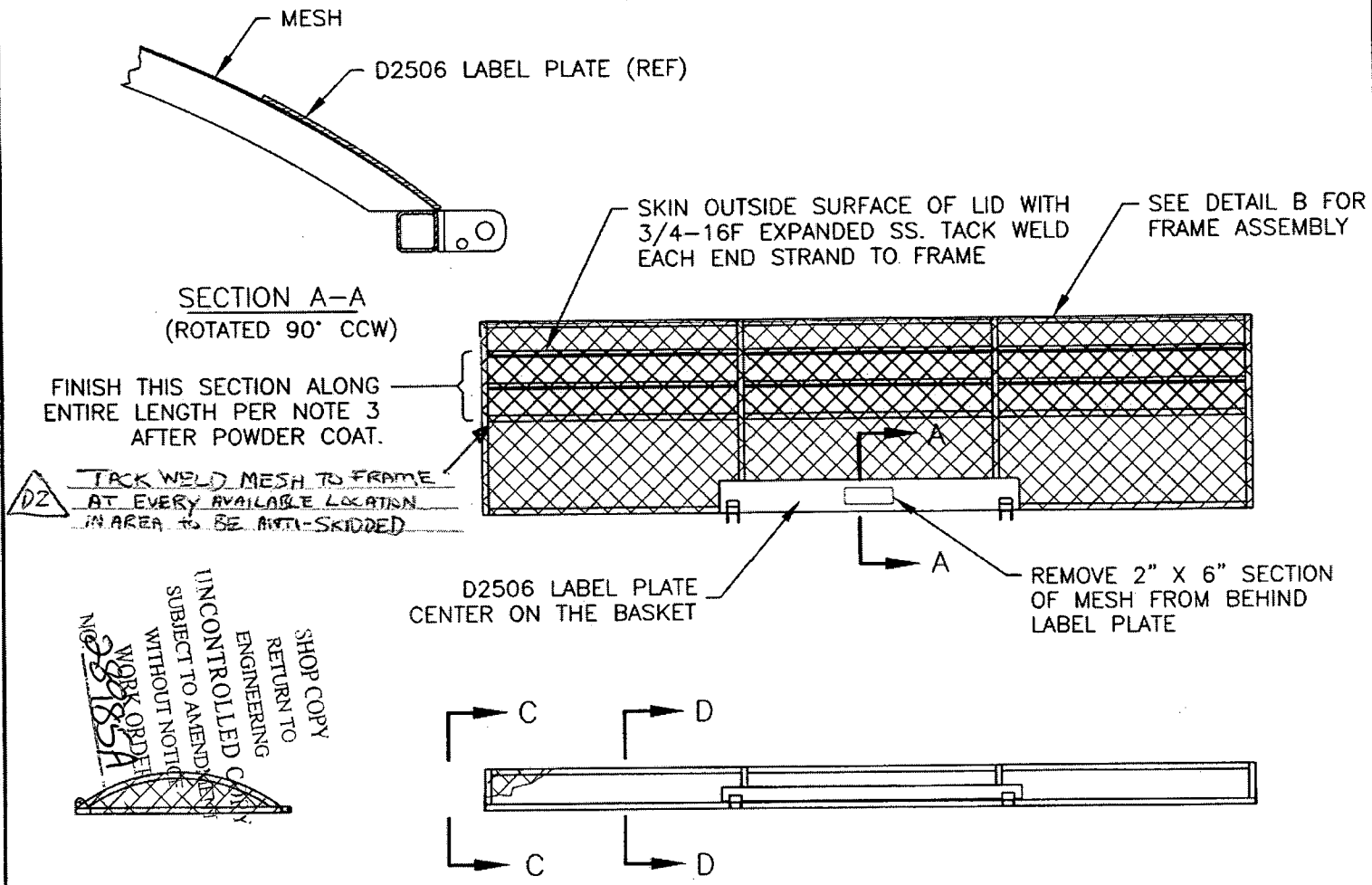
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DATE	01.04.19	DRAWING NO.	D2512	REV: D
		TITLE	BASKET LID ASSEMBLY (350/212)	SHEET 2 OF 4
		SCALE	1:20	



- D2512 BASKET LID ASSEMBLY**
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
 - 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES

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NO. 281854

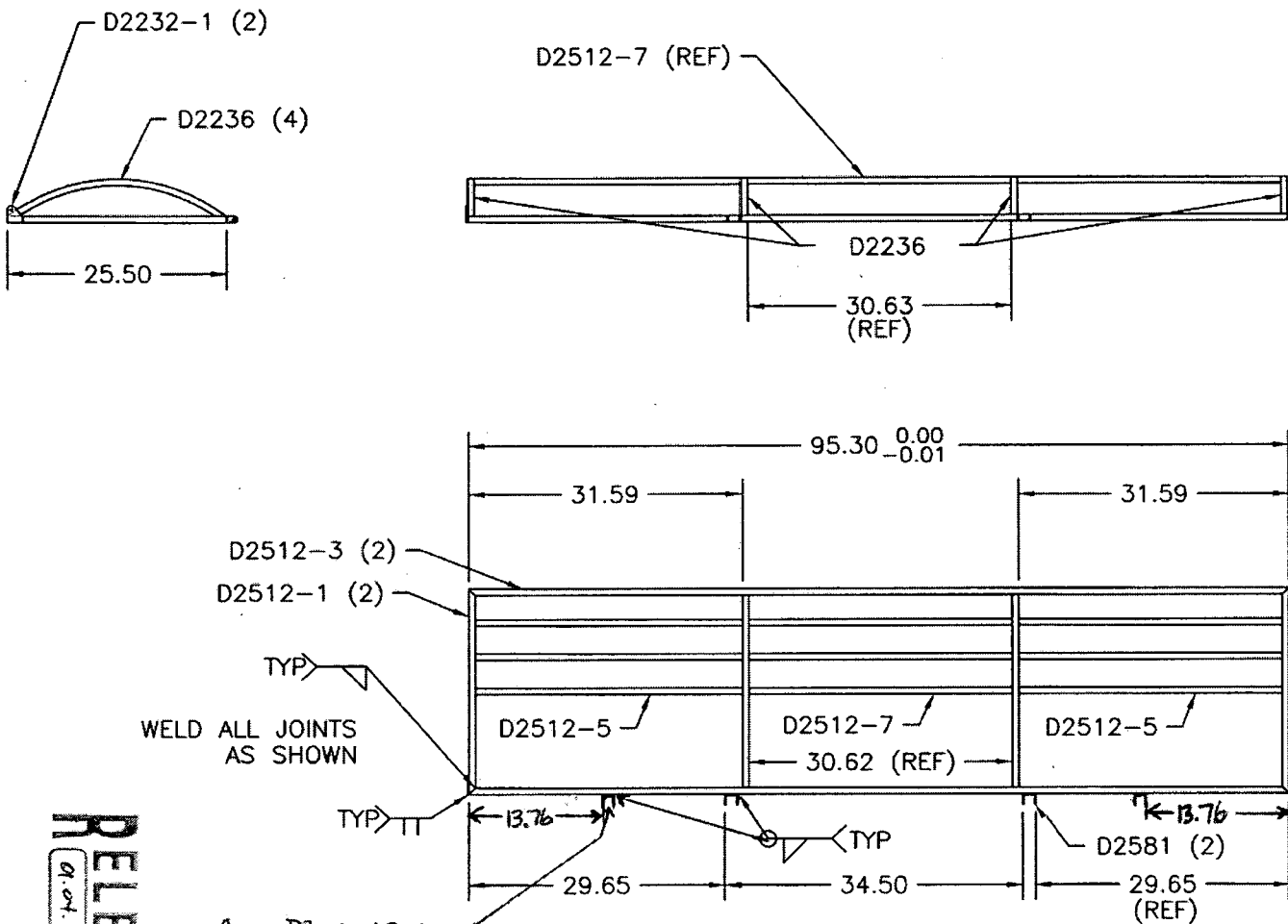
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CHECKED	APPROVED	DRAWING NO.
01.04.19		D2512
DATE	TITLE	SHEET 3 OF 4
	BASKET LID ASSEMBLY (350/212)	SCALE
		1:20



TYP
WELD ALL JOINTS
AS SHOWN

D2512-117 CLEVIS
ADD FOR D130-701-041
ONLY (2 PLACES)

DETAIL B

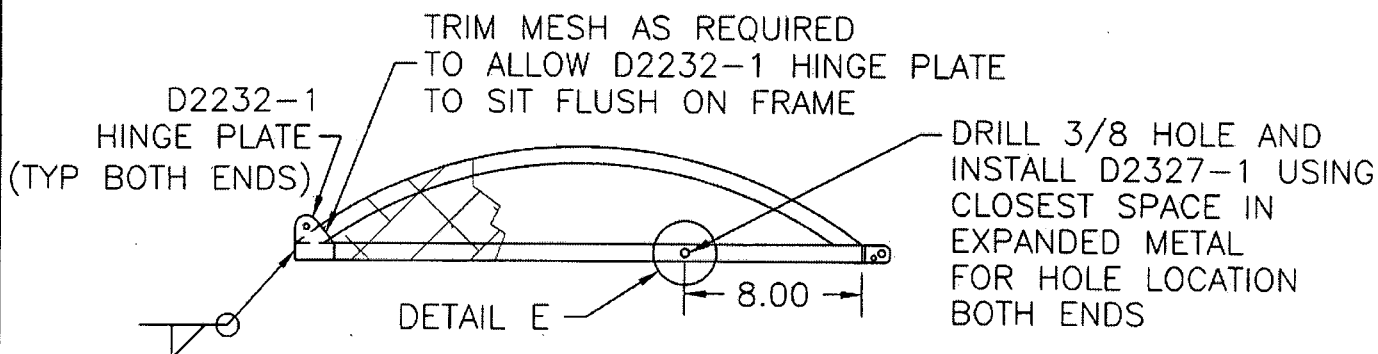
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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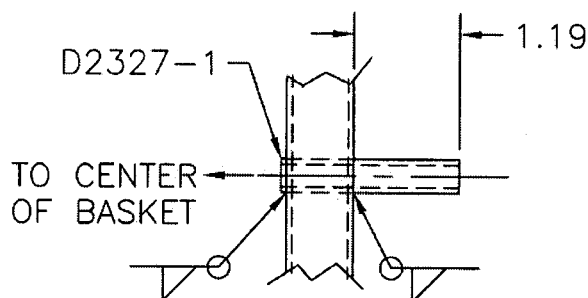
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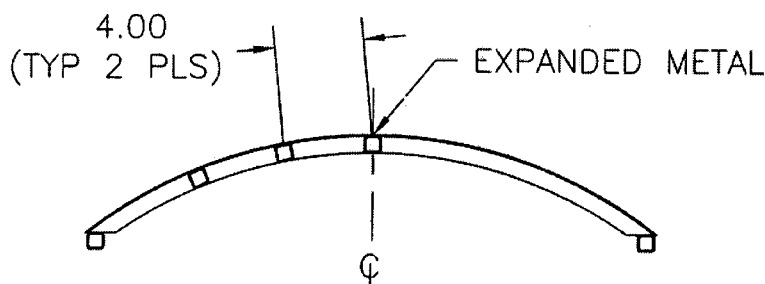
DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



SECTION C-C SIMILAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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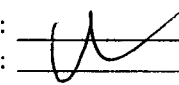
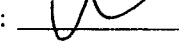
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Date: Friday, 27/04/2007 10:12:41 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D205-541
Job Number	: 32083		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 27/04/2007 S.O. No. : N/A	Drawing Number	: ECN954-UPDATE PAPRW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : OVERHEAD	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	: 	Due Date	: 04/05/2007 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
REMOVE FROM STK

D205-541-043

D205-541-044

B28985

B29975 B29130 7/4/27 SG

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS
FAA STC: SR00696NY

AND RETURN TO STK

7/4/27 7/4/27 SG

3.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

7/4/27 SG 07/04/27

Job Completion



u 04-04-27